

Work Order ID 83106

83106

Page 1

Thursday, April 12, 2012 4:10:57 PM

Item ID: DSI 9517-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Alternate Wearplate Installation

Start Date: 4/12/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: 

Date: 12/04/12

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI 9517

B

0.00

100

DOCUMENT CONTROL

DC

Memo

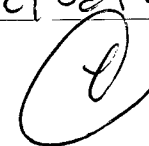
0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9517-011 CHG002

DA 16 12/04/12

MLJ 12/08/12



110

Pick Kit

0.00

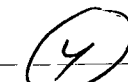
110

Packaging

Memo

0.00

Packaging

12/08/12  SP

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DA 16 12/04/12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 12, 2012 4:11:01 PM

Page 1

Work Order ID: 83106

83106

Parent Item: DSI 9517-011

DSI 9517-011

Parent Item Name: Alternate Wearplate Installation

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC
11.11.01 as per chg002 DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4C53A
AN4C53A
Bolt

Purchased No

110 Each 78.0000

4

16

**

1122193

Location

Loc Qty

Loc Code

ST361

78

121183

76

121184

2

D3403-5
D3403-5
Bushing

Manufactured No

110 Each 150.0000

8

32

**

85664 29X

Location

Loc Qty

Loc Code

ST042

150

79740

7

80221

32

81531

111

D4095-041
D4095-041
Wearplate Assembly

Manufactured No

110 Each 5.0000

0

4

**

85616

Location

Loc Qty

Loc Code

FP001

5

78996

5

D4095-043
D4095-043
Wearplate Assembly

Manufactured No

110 Each 6.0000

0

4

**

85610 12/2/27 (4)

Location

Loc Qty

Loc Code

FP001

6

78995

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REFERENCE ONLY

REF. CANADIAN STC: SH05-37
REF. FAA STC: SR01583SE
REF. EASA STC: EASA.IM.R.S.01126

PURPOSE:

The purpose of this service instruction is to introduce an alternate wearplate installation for the D412-742-011/-013 Skidtube Installations at CHG 006 or earlier. D412-742-011/-013 at CHG 007 or later have incorporated the new Wearplate kit. The new DSI-9517-011 Wearplate Kit consists of new wearplates destined to replace existing D3564-1/-3 Wearshoes and eliminates the need for D3566-1/-3 Gaskets. The components in the DSI-9517-011 Wearplate Kit are as defined in the parts list on sheet 4 of this service instruction.

INSTALLATION PROCEDURE:

Replace D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets with D4095-041/-043 Wearplates Assemblies as follows:

1. Remove existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets per Item 32.6.1 of ICA-D412-742. It might be necessary to loosen the aft end of D3564-5 Wearshoe and D3566-5 Gasket.
2. Remove qty.(4) AN4C52A Bolts, D3403-1 Bushings, and qty.(8) D3672-11 Washers as indicated in Figures 1 and 2 of this service instruction.
3. Inspect the skidtube and saddles per Chapter 5 of ICA-D412-742.
4. Seal existing inserts located on both sides of the skidtube in area shown in Figures 1 and 2 of this service instruction using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant.
5. Locate the DSI-9517-011 Wearplate Kit as shown in Figure 1 and 2 of this service instruction.
6. Transfer drill qty.(2) Ø0.438 hole from the skidtube/saddle to the D4095-041/-043 Wearplates Assemblies. Deburr. Touch up finish per Item 5.2.14 of ICA-D412-742 as required.
7. Install the DSI-9517-011 Wearplate Kit using the same AN3C hardware as shown in ICA-D412-742. Torque to 15-25 in-lbs (1.7-2.8 N-m).
8. Install D3403-5 Bushings and AN4C53A Bolts in lieu of D3403-1 Bushings and AN4C52A Bolts removed at step 2 above. Ensure that the nuts on the AN4C Bolts are on the inboard side of the skidtube. Torque to 50-70 in-lbs (5.7-7.9 N-m).
9. Amend weight and balance per the Weight and Balance Table below.

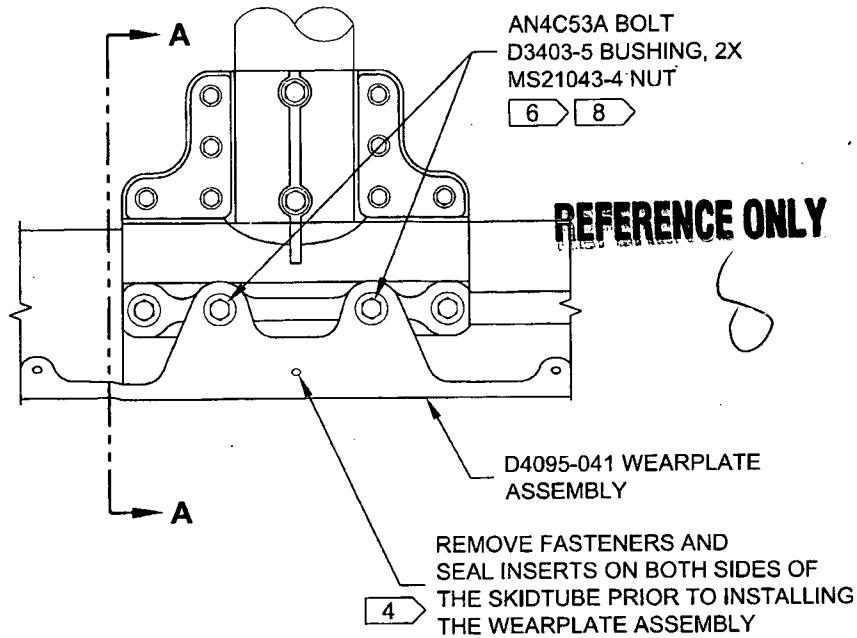
WEIGHT AND BALANCE:

Use the following weight and balance information for DART D412-742-011/-013 skidtube and saddle installations equipped with DSI-9517-011 Wearplate Kit.

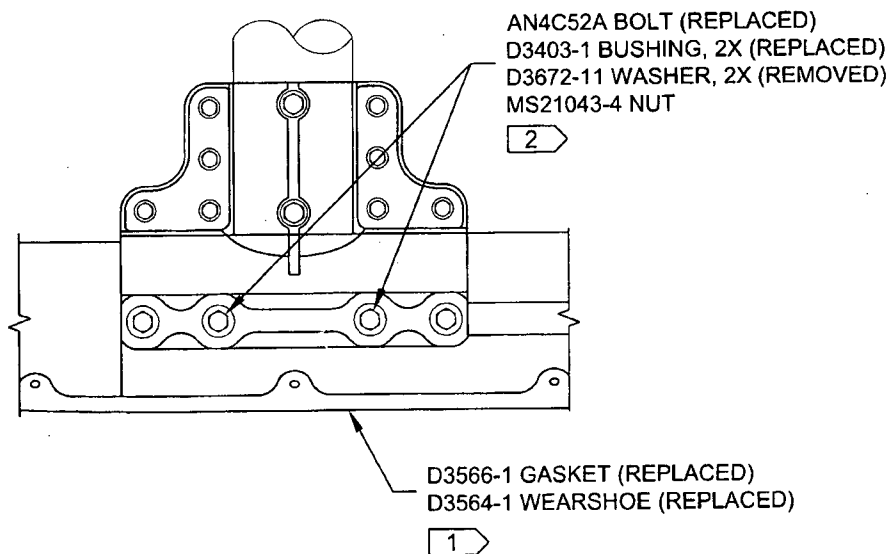
INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D412-742-011 Float Skidtube Installation at CHG 007, or earlier CHG # with DSI-9517-011 kit installed	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kG	130 in 3.3 m	9100 in-lb 105 m-kG
D412-742-013 Float Skidtube Installation at CHG 007, or earlier CHG # with DSI-9517-011 kit installed	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kG	130 in 3.3 m	9100 in-lb 105 m-kG

B	ITEM 21B AND 22B REMOVED FROM PARTS LIST		XDF	11.10.11
A	NEW ISSUE		MB	10.04.21
REV.	DESCRIPTION		BY	DATE
DESIGN	J	DART AEROSPACE USA, INC KENT, WA		
DRAWN	XDF			
CHECKED	df	DRAWING NO.	REV. B	
MFG. APPR.	N/A	DSI 9517	SHEET 1 OF 6	
APPROVED	[Signature]	TITLE	SCALE	
DE APPR.	[Signature]	ALTERNATE WEARPLATE KIT	NTS	
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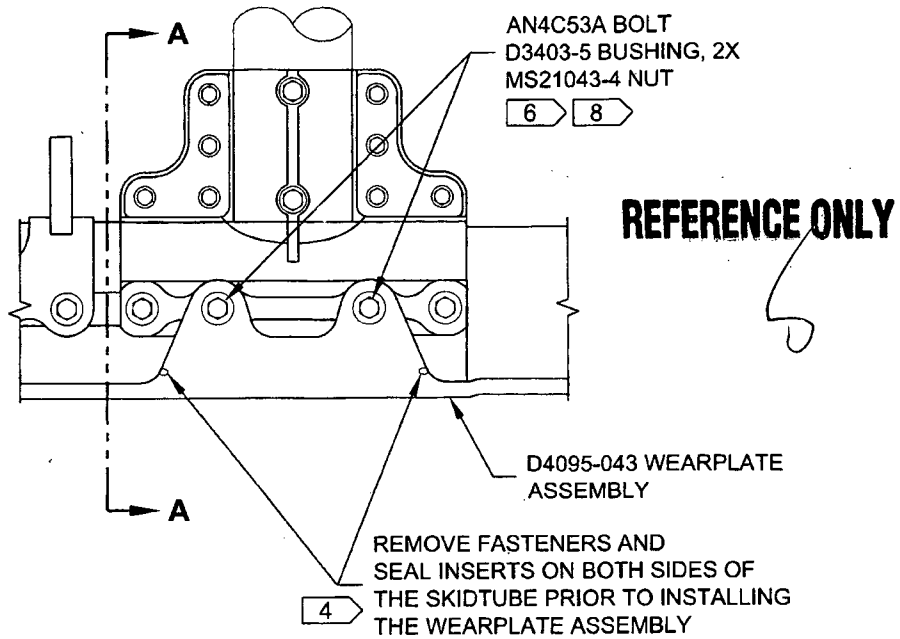
WAS:



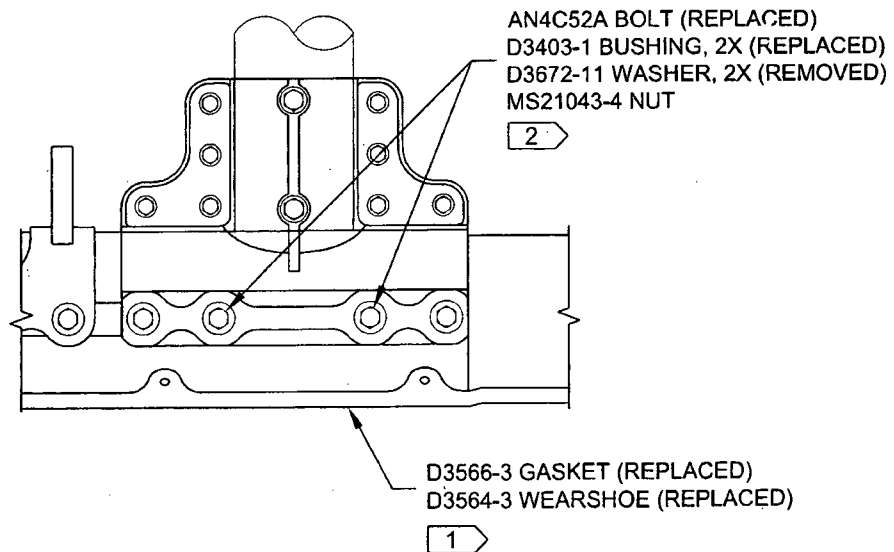
**FIGURE 1: CHANGE AT FORWARD SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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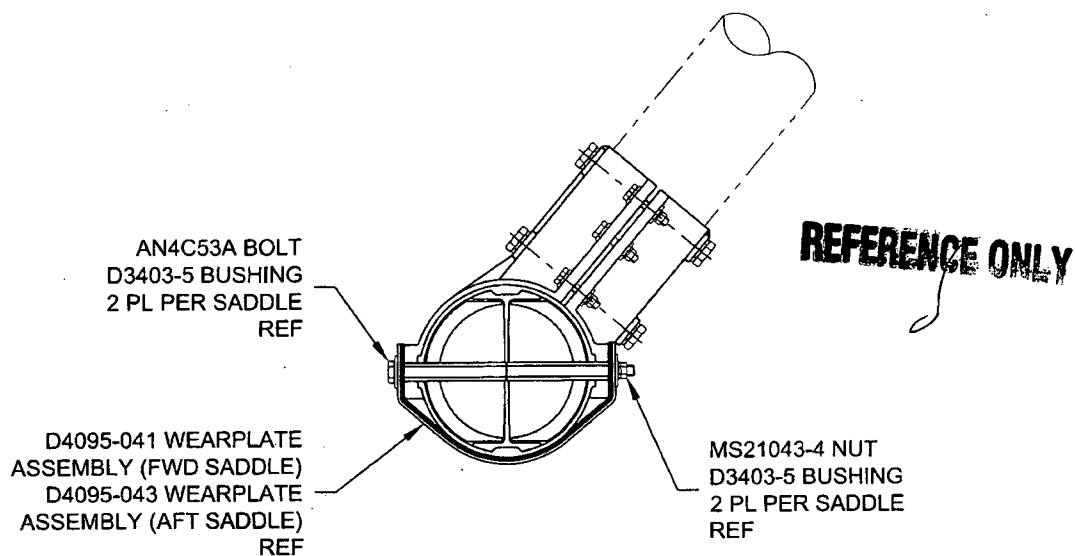


WAS:



**FIGURE 2: CHANGE AT AFT SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

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MFG. APPR.	N/A	DSI 9517	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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SECTION A-A

DSI-9517-011 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9517-011	WEARPLATE KIT
8	D3403-5	BUSHING
1	D4095-041	WEARPLATE ASSEMBLY
1	D4095-043	WEARPLATE ASSEMBLY
4	AN4C53A	BOLT

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
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~~RESTRICTED~~

THE PARTS LISTS IN SECTION 32.15 OF ICA-D412-742 (PAGES 53 AND 55) AND SECTION 5.1 OF IIN-D412-742 (PAGES 16 AND 17) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.15 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.1 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -011	QTY -041	QTY -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

3		10		AN3C6A	BOLT (REMOVED QTY.2)
4		4		AN3C7A	BOLT (REMOVED QTY.4)
5		38		AN960C10L	WASHER (REMOVED QTY.6)
21A		1		D4095-041	WEARPLATE ASSEMBLY
22A		1		D4095-043	WEARPLATE ASSEMBLY
46	8			D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8			D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4			AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4			AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8			D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12		AN3C6A	BOLT
4		8		AN3C7A	BOLT
5		44		AN960C10L	WASHER
21A		1		D3564-1	WEARPLATE
21B		1		D3564-3	WEARPLATE
22A		1		D3566-1	GASKET
22B		1		D3566-3	GASKET
46	16			D3403-1	BUSHING
49	8			AN4C52A	BOLT
53	16			D3672-11	WASHER

DESIGN	<i>J</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>J</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 5 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	ALTERNATE WEARPLATE KIT	NTS
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THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -013	QTY -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

3		10	AN3C6A	BOLT (REMOVED QTY.2)
4		4	AN3C7A	BOLT (REMOVED QTY.4)
5		38	AN960C10L	WASHER (REMOVED QTY.6)
21A	1		D4095-041	WEARPLATE ASSEMBLY
22A	1		D4095-043	WEARPLATE ASSEMBLY
46	8		D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8		D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4		AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4		AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8		D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12	AN3C6A	BOLT
4		8	AN3C7A	BOLT
5		44	AN960C10L	WASHER
21A		1	D3564-1	WEARPLATE
21B		1	D3564-3	WEARPLATE
22A		1	D3566-1	GASKET
22B		1	D3566-3	GASKET
46	16		D3403-1	BUSHING
49	8		AN4C52A	BOLT
53	16		D3672-11	WASHER

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